

Monday, July 25, 2016 2:27:37 PM

Page 1

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
3		3			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____		

Work Order ID 149544

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149544

Page 2

Item ID: D066-1001-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/13/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D066-1001-013

Location: _____

PPP Rev: _____

fs 013

2X

DAS
27
9-89DAS
28
9-89

DEC 1 1 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.03

DAS
21
9-89

DEC 1 5 2016

DAS
21
9-89

DEC 1 5 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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OTHER : _____					

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149544

D066-1001-013

Required Date: 7/25/2016

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP
REV:B 13.12.03 AS PER IIN REV.B DD VERF:JLM IPP REV:C
15.04.08 AS PER CHG003 DD VERF:JLM

DAS 6
9-89

DAS 6
9-89

DAS 6
9-89

DAS
28
9-89

DQA: _____ Date: _____

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 149544

149544

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/13/2016

Required Date: 7/25/2016

Start Qty: 2.00

Required Qty: 2.00

D4930-3 Manufactured No

Each 1.0000

D4930-3

Bearpaw

**

2 4

149656

SEP 29 2016

DAS 6 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST462A

1

112356

1

D4952-041

Manufactured No

Each 0.0000

D4952-041

Wearplate Assembly

**

4 8

145566x6

DEC 15 2015

DAS 6 9-89

DAS 27 9-89

D4953-1

Manufactured No

Each 12.0000

D4953-1

Cushion

**

4 8

SEP 29 2016

DAS 6 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

st543

12

147882

12

AN4-12A

Purchased No

Each 94.0000

AN4-12A

Bolt

**

4 8

SEP 29 2016

DAS 6 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

84

m134606

84

DAS 28 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Work Order ID: 149544

149544

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/13/2016

Required Date: 7/25/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-15A Purchased No

Each 366.0000

AN4-15A
Bolt

**

SEP 29 2016

DAS 6 DAS 27
9-89 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

GA	26	
120449	26	
over003	250	
m134955	150	
m135297	100	
ST343	90	
m135127	90	

AN4-16A Purchased No

Each 311.0000

AN4-16A
Bolt

**

SEP 29 2016

DAS 6 DAS 27
9-89 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

FG	5	
121541	5	
over003	200	
M135127	100	
M135297	100	
ST343	106	
M135058	106	

DQA: _____ Date: _____



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		OTHER : ☐							

Picklist Print

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Work Order ID: 149544

149544

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/13/2016

Required Date: 7/25/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

Each

1,977.000

8

16

NAS1149D0463J
WASHER

**

135409

SEP 29 2016

DAS 6 27
9-89 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

GA

480

M132035

15

M134508

65

M135056

400

ST260a

600

M135056

600

ST263

897

M134943

897

MS21042L4

Purchased

No

Each

2,733.000

12

24

MS21042L4
Locknut

**

195470

SEP 29 2016

DAS 6 27
9-89 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

FP001

51

m133363

51

GA

156

m133769

156

OVER007

2000

m135127

1000

m135297

1000

ST3003

26

m134955

26

ST303

500

m135058

500

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 149544

Monday, July 25, 2016 2:27:37 PM

149544

Accept

N900040100

Setup

Stop *N.

Item ID: D066-1001-013

Revision ID:

Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/13/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: DAS Date: AUG 02 2016 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1001	REV B	SEP 27 2016							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD066-1001-013								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
21
9-89
SEP 27 2016

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1001-011	8.3 lb	0.0 in	0.0 in-lb	123.89 in	1028 in-lb
Bearpaw Installation (Small)	3.74 kg	0.0 m	0.0 m-kg	3.14 m	11.7 m-kg
D066-1001-013	9.8 lb	0.0 in	0.0 in-lb	124.98 in	1225 in-lb
Bearpaw Installation (Large)	4.41 kg	0.0 m	0.0 m-kg	3.17 m	14.0 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D066-1001-011	BEARPAW INSTALLATION (SMALL)
	X	D066-1001-013	BEARPAW INSTALLATION (LARGE)
4	4	D3456-1	Washer
4	4	D3556-1	Clamp
8	8	D3601-1	Radius Block
2		D4930-1	Bearpaw
	2	D4930-3	Bearpaw
4	4	D4952-041	Wearplate
4	4	D4953-1	Cushion
4	4	AN4-12A	Bolt
4	4	AN4-15A	Bolt
4	4	AN4-16A	Bolt
8	8	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)